



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5124-1
Job Sheet 179391



Part No: D5124-1

Job Qty: 10 ea

Part Name: Fwd Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 6/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP rev A RQ verified by JLM 14/08/08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/18/18	0.00	0.00	Start Up Machining-3		<i>2018-06-18</i>
100	CNC Vertical Machining	10 pcs		6/18/18	0.37	15.38	HAAS1-4		<i>[Signature]</i>
110	QC	10 pcs		6/18/18	0.00	0.00	QC2 Machining-3		<i>[Signature]</i>
120	QC	10 pcs		6/18/18	0.00	0.00	QC8 Machining-3		<i>S.C.L. 18-07-03</i>
130	Packaging	10 pcs		6/18/18	0.00	0.00	Packaging3-2	<i>LG054</i>	<i>21 JUL 06 2018</i>
140	QC21-SA	10 Ea		6/18/18	0.00	0.00	QC21		<i>21 JUL 06 2018</i>

Part Op 100 - Machine as per Folio FB340
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5124-1TRN	Support	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5124-1TRN	5	11	0

3079478 → 5

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Support	2.028Inches ± 0.030	2.058 1.998		
2	Fwd Support	0.250Inches ± 0.030	0.280 0.220	Radius	
		88Inches	+ 0.005 - 0.001		
		257Inches	+ 0.006 - 0.001		
		150Inches ± 0.010	3.160 3.140		
		276Inches ± 0.010	0.286 0.266		
		110Inches ± 0.030	0.440 0.380		



Container No: S082094



Part: D5124-1

Job No: 179391

Serial No/Batch: S082094

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/05/18

Plex 6/18/18 2:26 PM Dart.lajeunesse.marie

8	Fwd Support	3.100Inches $\pm$ 0.010	3.110 3.090	
9	Fwd Support	1.472Inches $\pm$ 0.010	1.482 1.462	
10	Fwd Support	2.796Inches $\pm$ 0.010	2.806 2.786	
11	Fwd Support	0.230Inches $\pm$ 0.030	0.260 0.200	
12	Fwd Support	1.109Inches $\pm$ 0.010	1.119 1.099	
13	Fwd Support	0.250Inches $\pm$ 0.030	0.280 0.220	Radius

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DART AEROSPACE LTD				Work Order:	174 944
Description:				Part Number:	DS124-1
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.018	2.038						
B	1.890	1.910						
C	1.890	1.910						
D	1.890	1.910						
E	3.140	3.160						
F								
G								
H								
I								
J								
K								
L								

Measured by:

Date:

HAAS Section								
AA	2.018	2.038		2.030	2.032	2.032	2.032	2.030
AB	R.230	R.280		R.250	R.250	R.250	R.250	R.250
AC	.187	.193		.189	.189	.189	.189	.189
AD	.256	.262		.256	.256	.256	.256	.256
AE	3.140	3.160		3.155	3.159	3.154	3.154	3.154
AF	.266	.286		.276	.275	.275	.275	.275
AG	.380	.440		.416	.415	.416	.417	.416
AH	3.090	3.110		3.099	3.099	3.100	3.099	3.099
AI	1.462	1.482		1.467	1.466	1.466	1.466	1.470
AJ	2.786	2.806		2.805	2.800	2.803	2.801	2.802
AK	.200	.260		.260	.260	.260	.260	.260
AL	1.099	1.119		1.119	1.119	1.117	1.117	1.119
AM	R.220	R.280		R.250	R.250	R.250	R.250	R.250
AN								
AO								
AP								
AQ								
AR								
AS								
AT								
AU								
Accept/Reject								

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 174944
Description:		Part Number: DS/24-1
Inspection Dwg:	Rev:	Page 1 of 1

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.018	2.038		2.028	2.029	2.029	2.028	2.029
AB	R.230	R.280		R.250	R.250	R.250	R.250	R.250
AC	.187	.193		.189	.189	.189	.189	.189
AD	.256	.262		.256	.256	.256	.256	.256
AE	3.140	3.160		3.154	3.154	3.154	3.148	3.147
AF	.266	.286		.275	.275	.274	.274	.274
AG	.380	.440		.415	.416	.415	.414	.415
AH	3.090	3.110		3.098	3.099	3.099	3.099	3.099
AI	1.462	1.482		1.470	1.470	1.471	1.470	1.470
AJ	2.786	2.806		2.801	2.799	2.800	2.799	2.799
AK	.200	.260		.260	.260	.260	.260	.260
AL	1.099	1.119		1.119	1.118	1.118	1.119	1.119
AM	R.220	R.240		R.250	R.250	R.250	R.250	R.250
AN								
AO								
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: M.M.	Checked by: J.C.L.	QC Inspector:
Date: 2018/06/15	Date: 18-07-08	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	